

Date: Tuesday, 8/21/2007 3:43:16 PM
 User: Kim Johnston

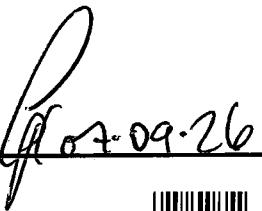
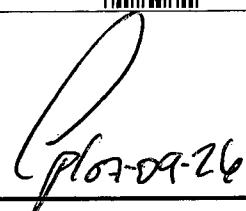
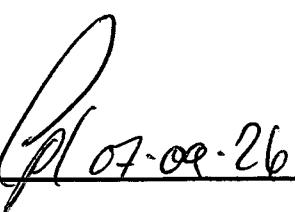
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FRAME WELDMENT		
Job Number	: 34177		Part Number	: D3330041		
Estimate Number	: 11202		Drawing Number	: D3330 REV C		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 8/21/2007		Type	: LARGE FAB ASSY		
Prsht Rev.	: NC		Drawing Revision	: C		
First Issue	: N/A		Material	: N/A		
Previous Run	: 30950		Due Date	: 9/15/2007		
Written By	:		Qty:	2 Um: Each		
Checked & Approved By	:		Handwritten signature: 07-08-22			
Comment	:		Est. A	05.01.13	New Issue KJ/JLM	
			est B	07.05.14	revC dwg	ec

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D33301	Panel		
		 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Panel Pick: ✓ Qty Part Number Description Batch 1 D3330-1 Panel <u>B30955</u> 				
2.0	D33302	Panel		
		 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Panel Pick: ✓ Qty Part Number Description Batch 1 D3330-2 Panel <u>B30958</u> 				
3.0	D33303	Panel		
		 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Panel Pick: ✓ Qty Part Number Description Batch 1 D3330-3 Panel <u>B30959</u> 				
4.0	D33305	Rail		
		 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Rail Pick: ✓ Qty Part Number Description Batch 1 D3330-5 Panel <u>B30960</u> 				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 34177

Part Number: D3330041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D33307 Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

✓ Qty Part Number Description Batch
1 D3330-7 Panel B34122

Plot 09-26

6.0 D33309 Top Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Top Plate

Pick:

✓ Qty Part Number Description Batch
1 D3330-9 Panel B34199

Plot 09-26

7.0 D333011 Long Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Long Pin Bracket

Pick:

✓ Qty Part Number Description Batch
1 D3330-11 Long Pin Bracket B23590

Plot 09-26

8.0 D333013 Short Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Short Pin Bracket

Pick:

✓ Qty Part Number Description Batch
1 D3330-13 Short Pin Bracket B23235

Plot 09-26

9.0 D333015 Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle

Pick:

✓ Qty Part Number Description Batch
1 D3330-15 Handle B34198

Plot 09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

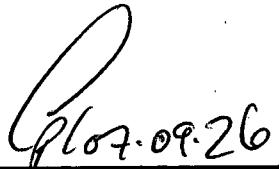
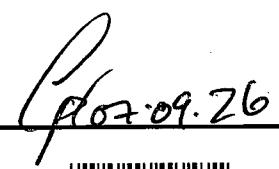
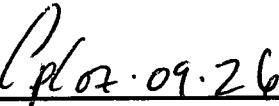
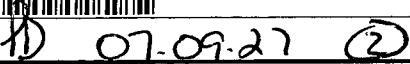
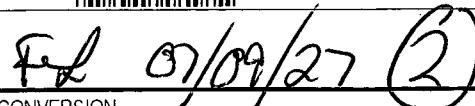
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:43:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FRAME WELDMENT
Job Number: 34177		Part Number: D3330041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
10.0	D333017	Handle Socket 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Handle Socket ✓ Pick: Qty Part Number Description Batch		 330956
11.0	D333019	Handle Rim 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Handle Rim ✓ Pick: Qty Part Number Description Batch		 330957
12.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1 Assemble and Weld as per Dwg Dwg D3330 using D3330-041T1 Identify as D3330-041		
13.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		
14.0	QC5	INSPECT WORK TO CURRENT STEP  start on Helicopter
Comment: INSPECT WORK TO CURRENT STEP		
15.0	POWDER COATING	POWDER COATING  m18052
Comment: POWDER COATING Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3		
16.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 01/09/28
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 34177

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/21/07 (2)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

8/21/07 (2)

Job Completion



8/21/07 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

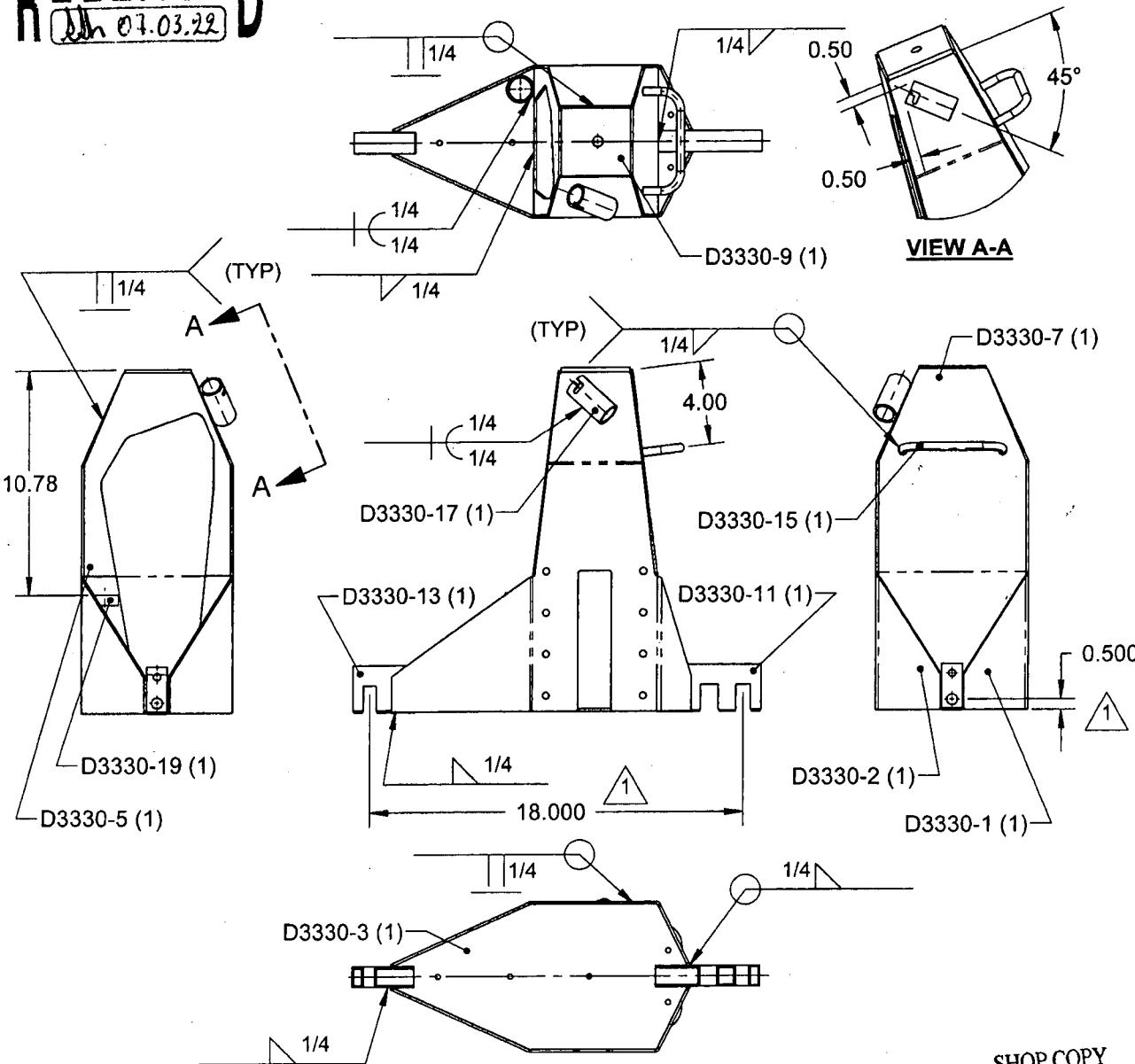
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DATE		DRAWING NO.	REV. C
		D3330	SHEET 1 OF 9
07.03.20		TITLE	SCALE
		FRAME WELDMENT	1:8

RELEASED
07.03.20

REV	DATE	DESCRIPTION
A	04.12.16	NEW ISSUE
B	05.02.26	RE-DESIGN
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125

**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

WORK ORDER NO. 3417

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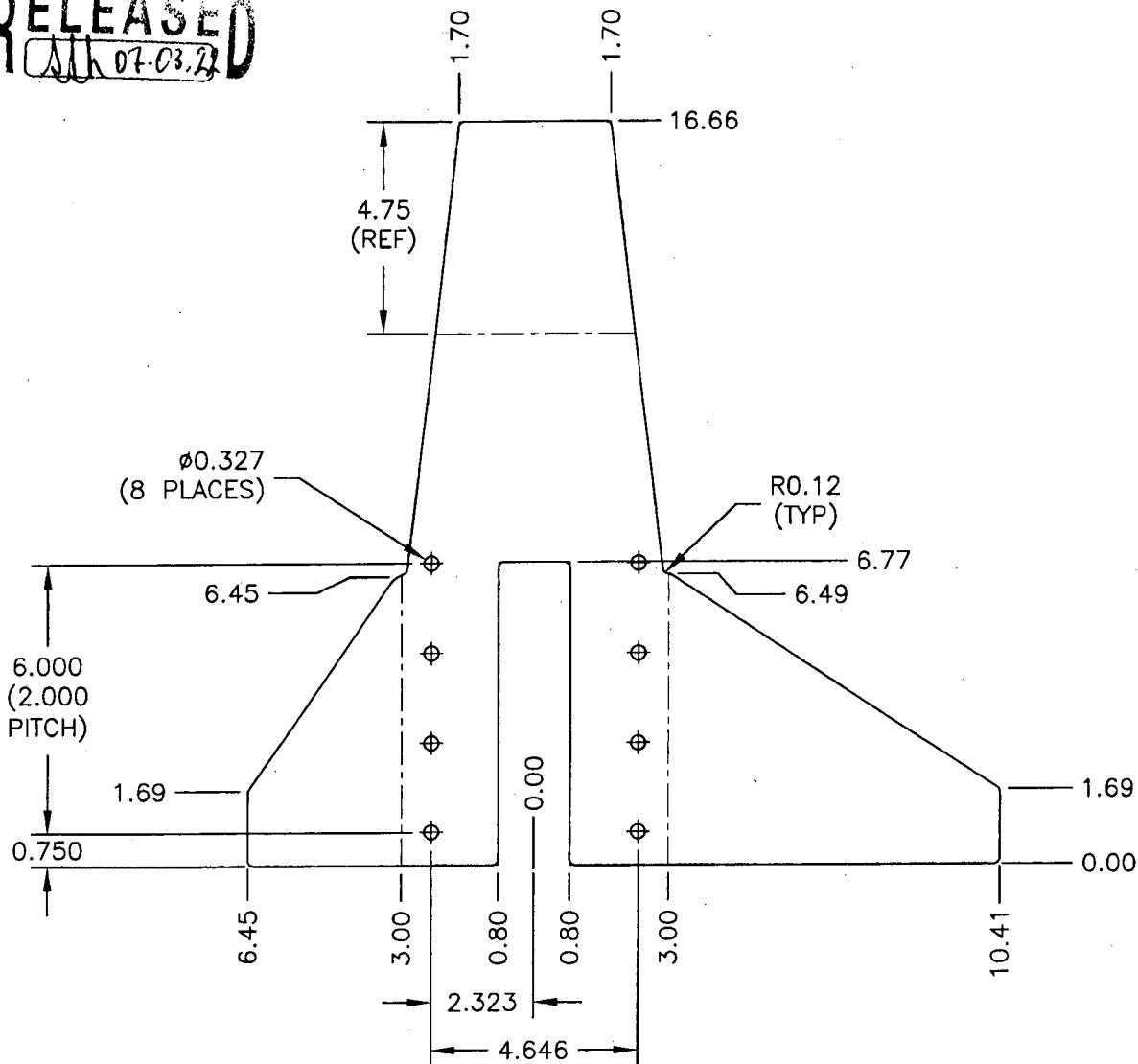
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DATE 07.03.20	TITLE FRAME WELDMENT		SCALE 1:4

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07-03-21



D3330-1 PANEL

NOTES:

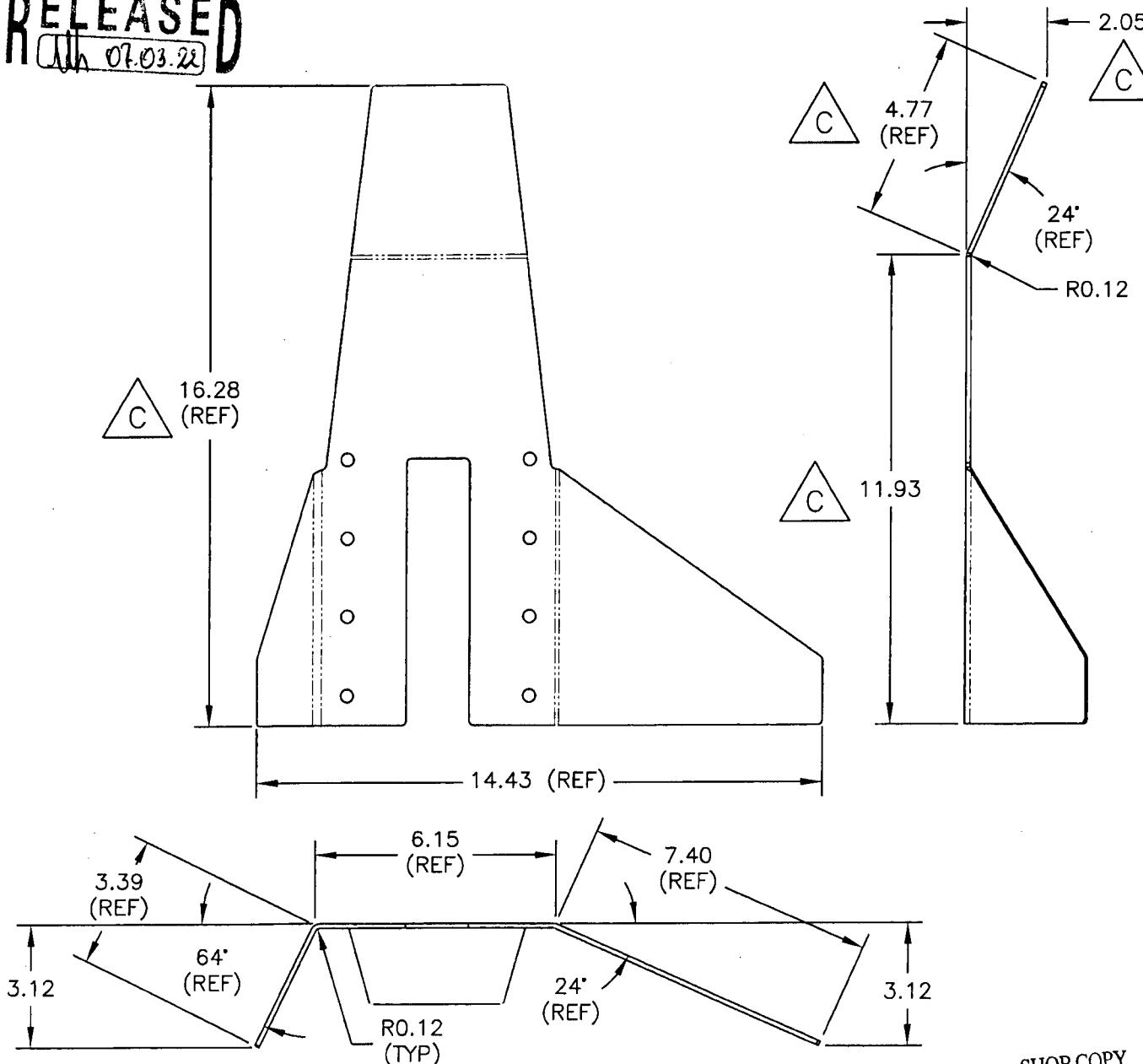
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125")
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE		REV. C SHEET 3 OF 9 TITLE FRAME WELDMENT SCALE 1:4

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07.03.20

D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

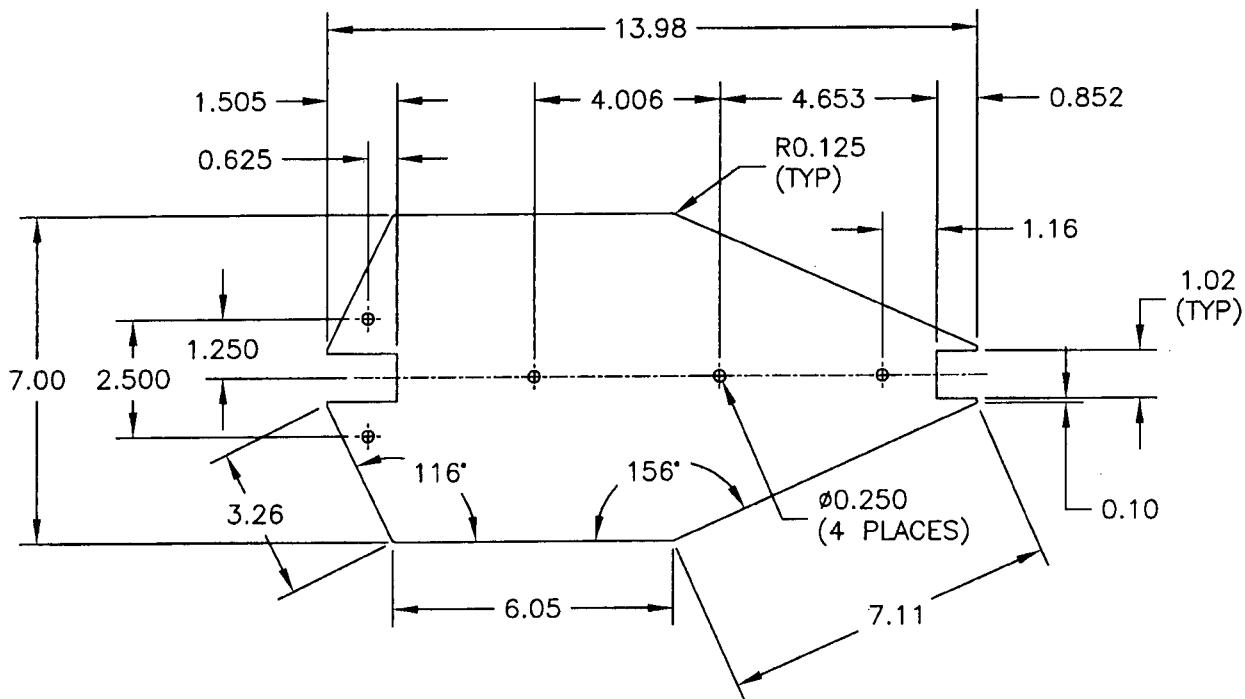
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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
07.03.20**D3330-3 PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
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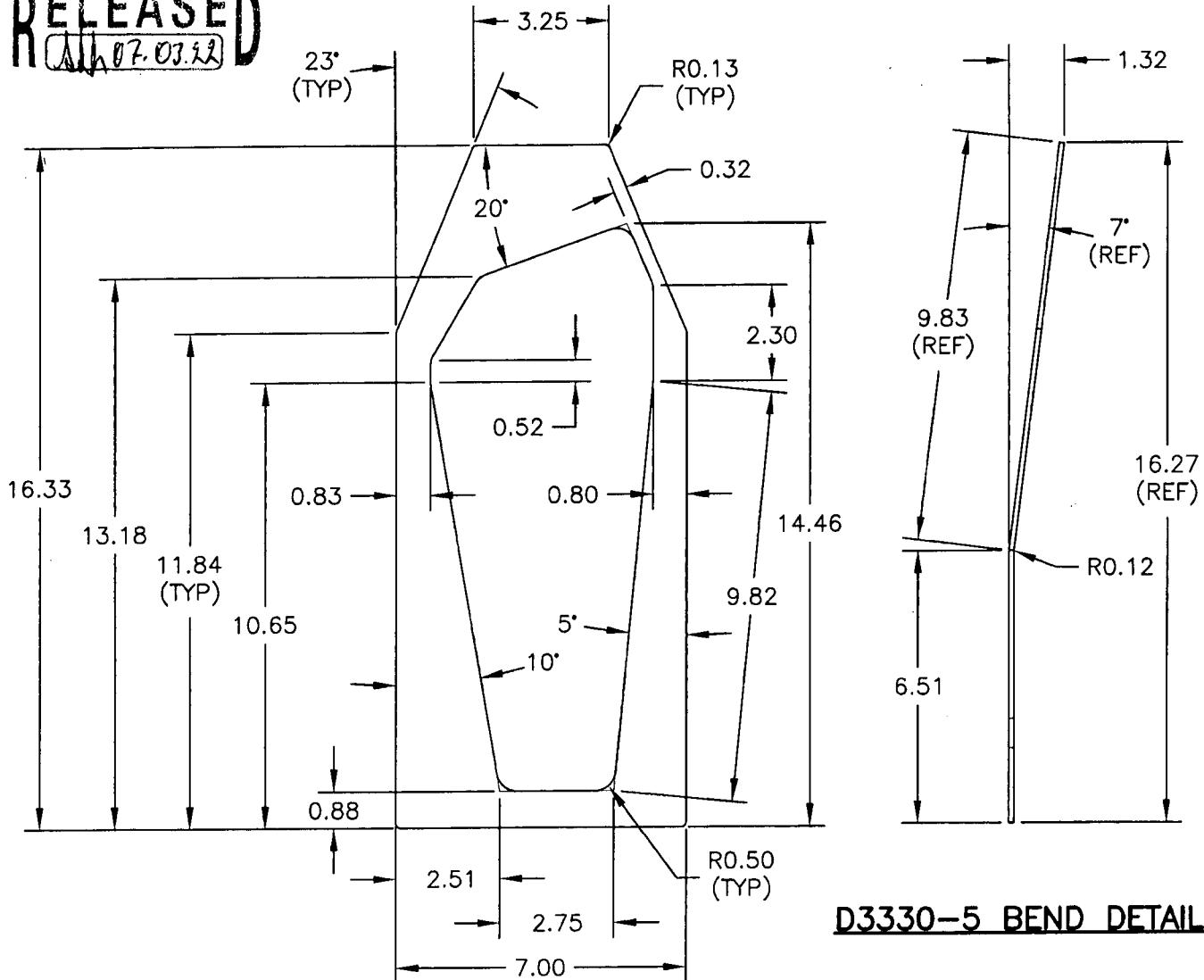
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DATE 07.03.20	TITLE FRAME WELDMENT		SCALE 1:4

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07.03.22

11 07.03.22



FLAT PATTERN

NOTES:

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 ENGINEERING
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 INCH THICK)
UNCONTROLLED COPY
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT
3) ALL DIMENSIONS ARE IN INCHES WITHOUT NOTICE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010 WORK ORDER
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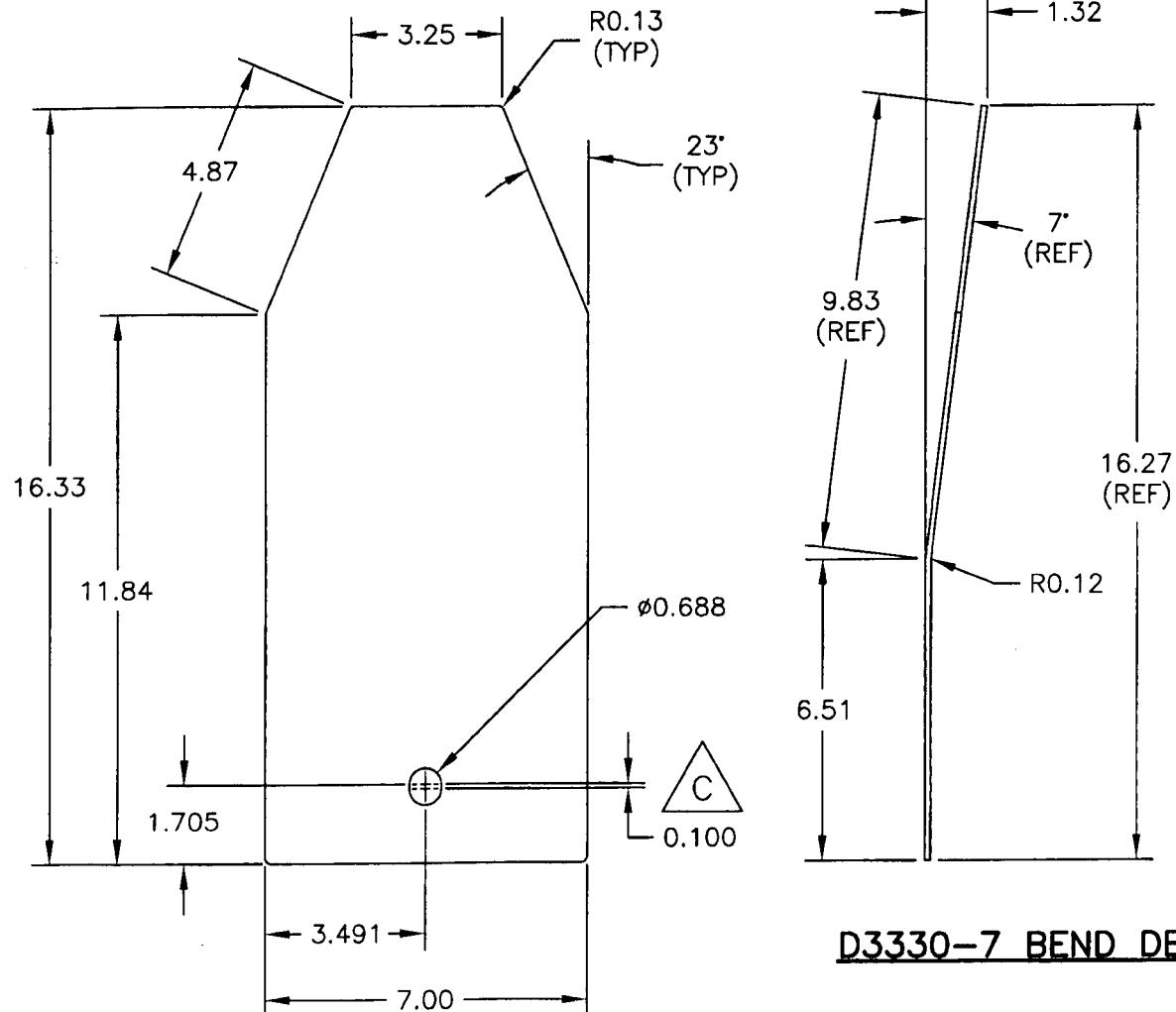
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WITHOUT NOTICE
WORK ORDER
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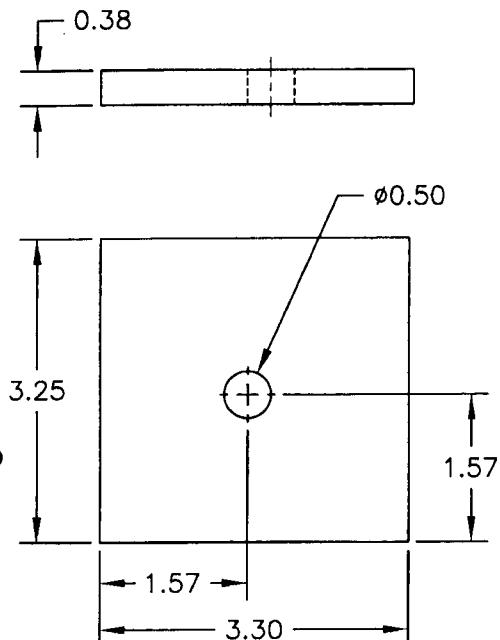
RELEASED
07.03.22FLAT PATTERNNOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 ENGINEERING 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNCONTROLLED COPY
- 3) ALL DIMENSIONS ARE IN INCHES SUBJECT TO AMENDMENT
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 WITHOUT NOTICE

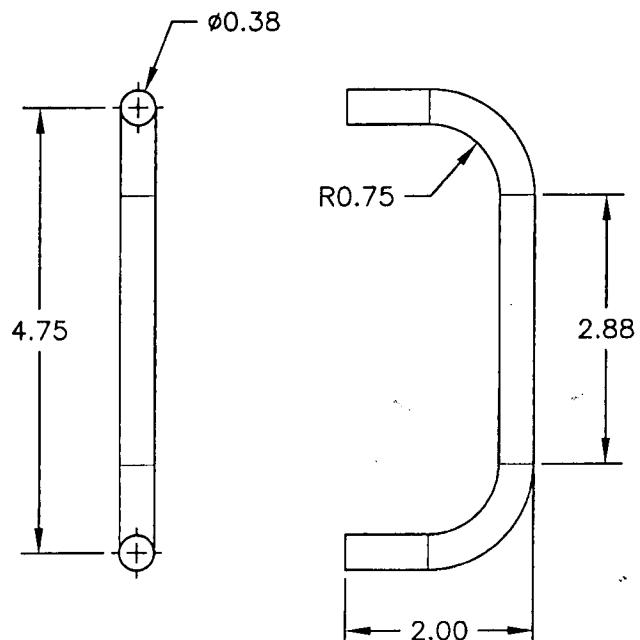
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07.03.20		D3330	SHEET 7 OF 9

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07.03.22

△ D3330-9 TOP PLATE



△ D3330-15 HANDLE

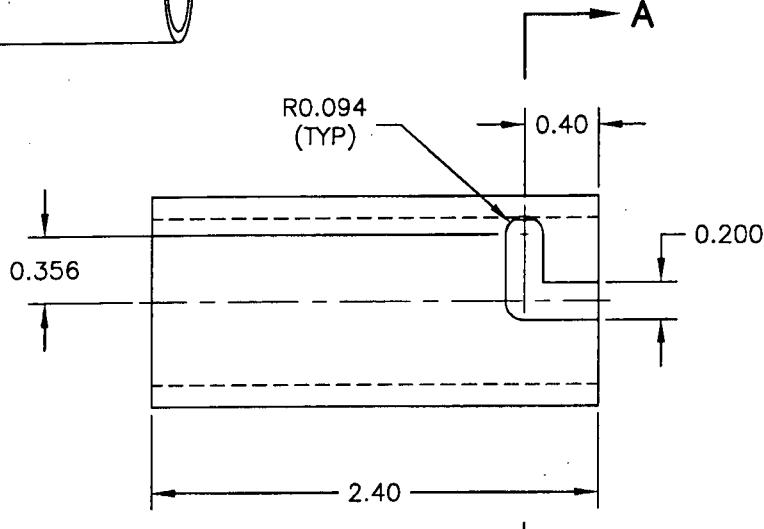
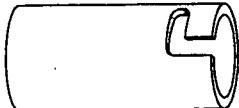
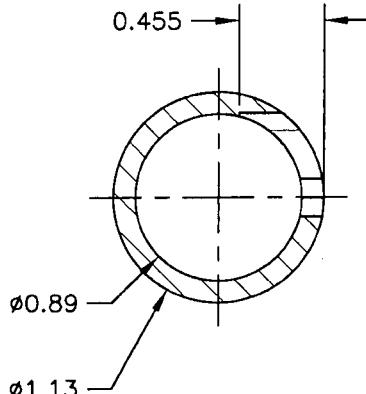
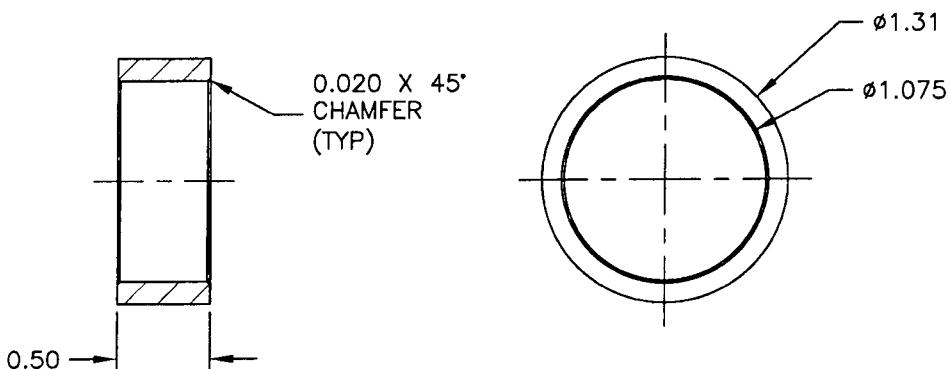
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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		D3330	SHEET 8 OF 9
DATE		TITLE	SCALE
07.03.20		FRAME WELDMENT	1:1

**RELEASED**
07-03-21SECTION A-AD3330-17 HANDLE SOCKETD3330-19 HANDLE RIMNOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097
(REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

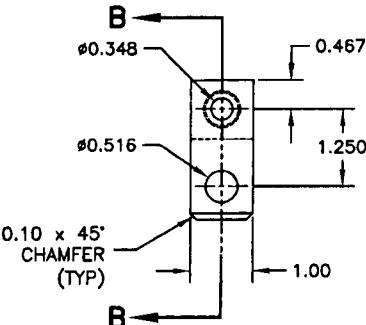
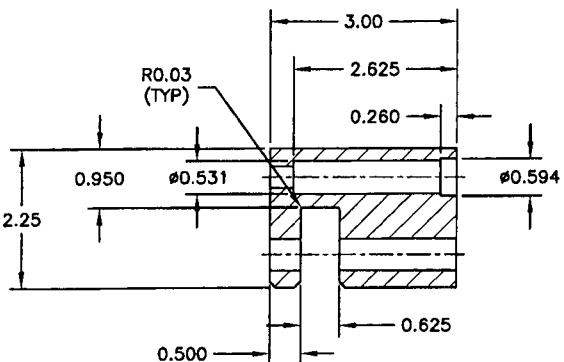
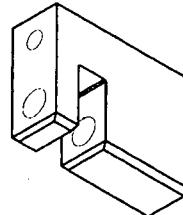
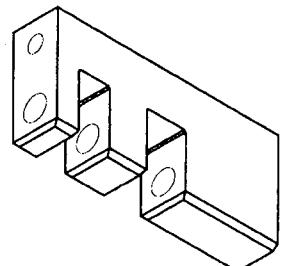
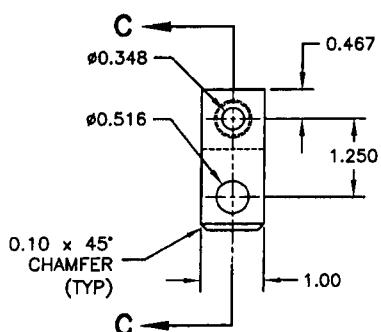
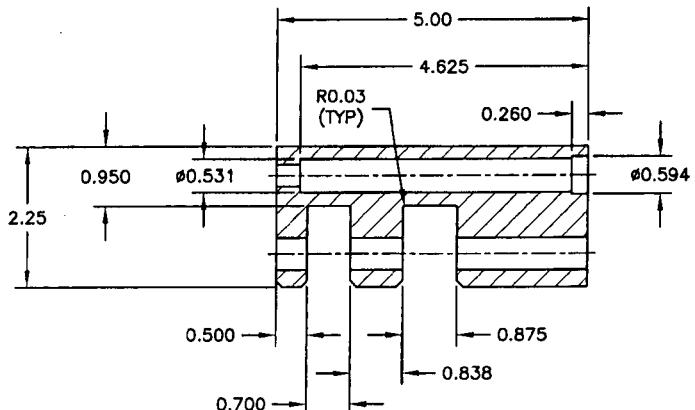
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		D3330	REV. C
DATE		TITLE	SHEET 9 OF 9
07.03.20		FRAME WELDMENT	SCALE
			1:3

**RELEASED**
07.03.20**SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK
(REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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